

# Work Order ID 69207

Wednesday, May 04, 2011 4:14:59 PM



Page 1

Item ID:	D350-607-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Utility-Basket					
Start Date:	5/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/13/2011	Req'd Qty:	1.00		Customer:	

## Reference:

Approvals:	Process Plan:		Date:	11-05-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D350-607-1	A								

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-043 CHG005 PRINT DWG PAGE: 41/42 OF 162								

8/10/13

OK Per BGR 11/05/10

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

JB 11/05/11

120	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D350-607 Seal Support Gusset with Sikaflex -291 Batch: M116745 Exp Date: 12/01/15								

JB 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69207**

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Page 2

Item ID: D350-607-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket

Start Date: 5/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00

Customer:







Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8 1105143					
140  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00		8 1105113					

W/O:		WORK ORDER CHANGES					
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**Work Order ID 69207**

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Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043 Location: _____								
170  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

MF  
11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 69207

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket






Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM  
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as  
per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3 		Manufactured	No			110	Each	0.0000	2	2 ✓			
Dart Logo label										115050 JB			
D350-607-241 		Manufactured	No			140	Each	2.0000	1	1			
Basket Clamp Assembly										69365 C4/10/12			
<div> <div>Location</div> <div>FG022</div> <div>67712</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2022-101 		Manufactured	No			110	Each	13.0000	5	5			
Spacer										67768 JB			
<div> <div>Location</div> <div>ST504</div> <div>66939</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>13</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2221 		Manufactured	No			110	Each	0.0000	1	1			
350 Basket Base										B69208			
D2258-200 		Manufactured	No			110	Each	15.0000	1	1			
Placard 200lb										JB 11/05/11			
<div> <div>Location</div> <div>ST505</div> <div>64284</div> <div>68928</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>5</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
										64284			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Page 2

Work Order ID: 69207

Parent Item: D350-607-043


Parent Item Name: Heli-Utility-Basket

Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

~~D2332-041~~  
  
 Lid Prop Assembly 6.69" long

Manufactured No

110 Each

3.0000

1

1



*EP 11/05/13*  
*B68830-1*

Location

Loc Qty


Loc Code

ST512

3

66233

3

D2530  
  
 Handle Weldment

Manufactured No

110 Each

13.0000

1

1



*JB*

Location

Loc Qty

Loc Code

ST506

13


66563

7

68363

6

*66563*

D2535  
  
 Spring

Manufactured No

110 Each

51.0000

2

2



*JB*

Location

Loc Qty

Loc Code


ST504

51

66764

51

*66764*

D2537  
  
 Bushing

Manufactured No

110 Each

44.0000

2

2



*JB 11/05/11*

Location

Loc Qty

Loc Code

ST504

44

65077

2

66972

42

*66972*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 69207

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No

110 Each 680.0000

2 2 ✓



Bumper

Location

Loc Qty

Loc Code

ST504

680

46064

680

46064

D2989-041 Manufactured No

110 Each 0.0000

1



Basket Lid Assembly

B69207 (1X)



1 5/4/05/12

D2989-043 Manufactured No

110 Each 0.0000

1



Basket Lid Assembly

B69210 (1X)



1 5/4/05/12

AN3-16A Purchased No

110 Each 161.0000

2



Bolt



2 ✓ JB

Location

Loc Qty

Loc Code

ST352

161

114752

11

116419

50

117441

100

114752 1X  
116419 1X

AN4-13A Purchased No

110 Each 5.0000

2



Bolt



2 ✓ JB 11/05/11

Location

Loc Qty

Loc Code

ST357

5

117313

5

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4 -

Work Order ID: 69207

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-22A Purchased No

110 Each

256.0000

7

7

✓



Bolt

Location

Loc Qty

Loc Code

ST359

256

114523

6

114784

100

116419

50

117313

100



114787

JB

✓

AN5-17A Purchased No

110 Each

82.0000

4

4

✓



Bolt

Location

Loc Qty

Loc Code

ST339

82

116590

52

117313

30



116590

JB

✓

MS20600-AD4W3 Purchased No

110 Each

1,385.000

2

2

✓



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1060

111636

360

117505

500

117601

200

WA018

325

107939

325



111636

JB

✓

AN960JD416 NAS1149D0463J Purchased No

110 Each

0.0000

14

14

✓



Washer



117291

JB

11/05/11

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 69207

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No

110 Each 3.0000 2 2 ✓



Washer

114503 JB L

Location

Loc Qty

Loc Code

FP-B

3

110153

3

AN960JD516 NAS1149D0563J Purchased No

110 Each 0.0000 4 4 ✓



Washer

117291 JB L

AN960JD8 NAS1149DN832J Purchased No

110 Each 0.0000 2 2 ✓



Washer

117316 JB L

NAS1515H4 Purchased No

110 Each 98.0000 2 2 ✓



Washer

JB L

Location

Loc Qty

Loc Code

ST277

98

111525

2

116169

46

117460

50

AN970-4 Purchased No

110 Each 107.0000 4 4 ✓



Washer

JB 11/05/11 L

Location

Loc Qty

Loc Code

ST344

14

115936

14

ST349

93

116900

43

117317

50

116900

Wednesday, May 04, 2011 4:15:08 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, May 04, 2011 4:15:08 PM

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Work Order ID: 69207



Parent Item: D350-607-043



Parent Item Name: Heli-Utility-Basket

Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

110 Each

2,414.000

2

2

✓



Nut

Location

Loc Qty

Loc Code

ST300

2414

116391

11

116540

437

116549

766

117441

800

117601

400

116540

MS21042L4

Purchased No

110 Each

5,152.000

9

9

✓



Nut

Location

Loc Qty

Loc Code

ST300

5152

116823

1352

117441

3000

117601

800

116823

MS21042L5

Purchased No

110 Each

1,203.000

4

4

✓



Nut

Location

Loc Qty

Loc Code

ST300

1203

116105

343

116548

260

117441

500

117591

100

116105

Wednesday, May 04, 2011 4:15:08 PM

Shop Packet Print

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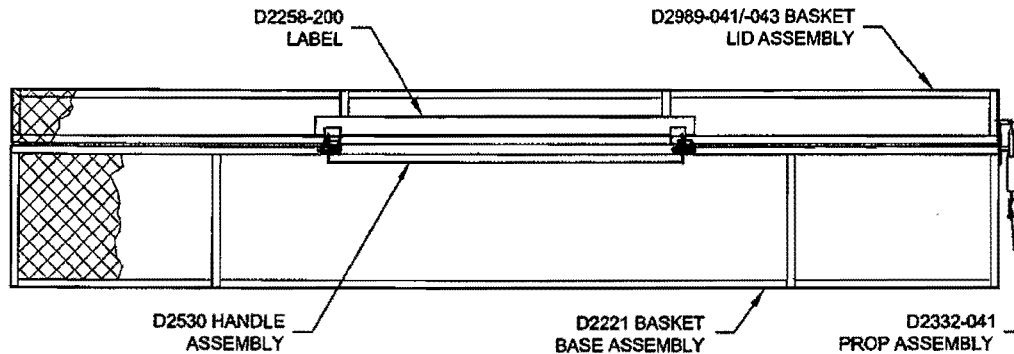
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

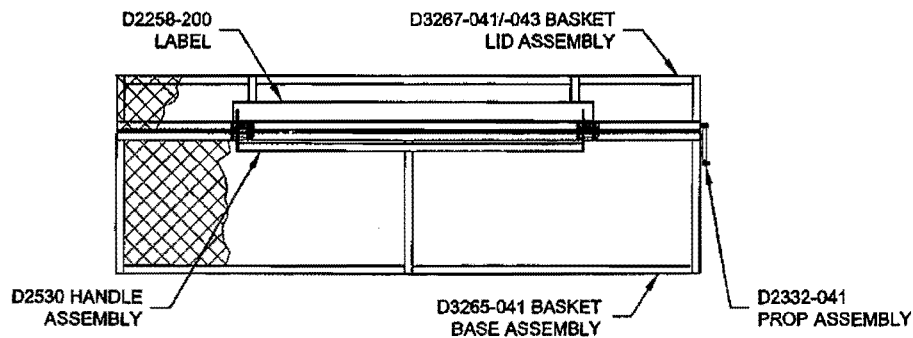
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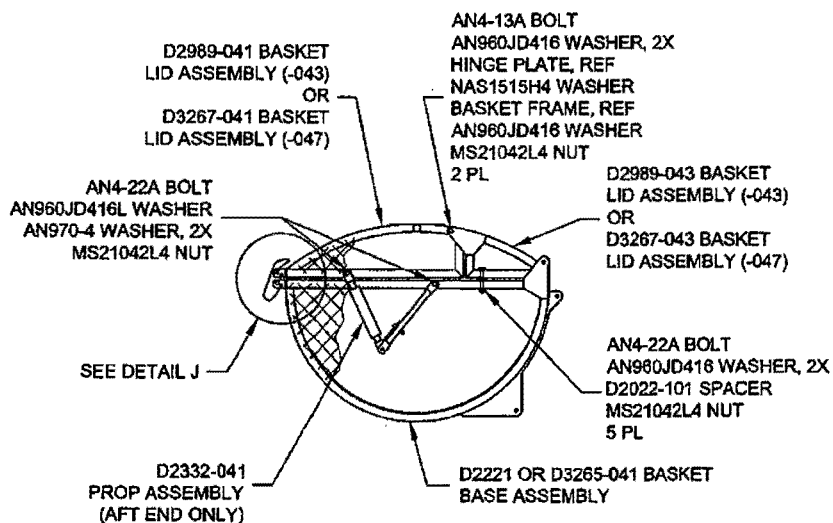
**NOTE:** Date & initial all entries



**D350-607-043 HELI-UTILITY- BASKET™**



**D350-607-047 HELI-UTILITY- BASKET™**



**VIEW C-C**  
**PROP ARM DETAIL**

**Figure 6– Basket Replacement Parts**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 19207

11-05-4

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Revision: **A**  
Date: 10.03.10

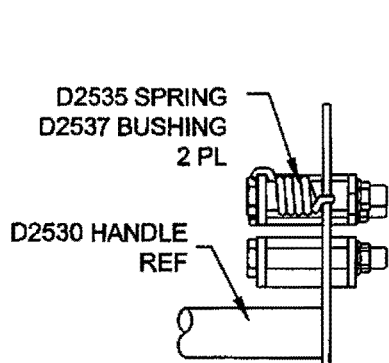
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

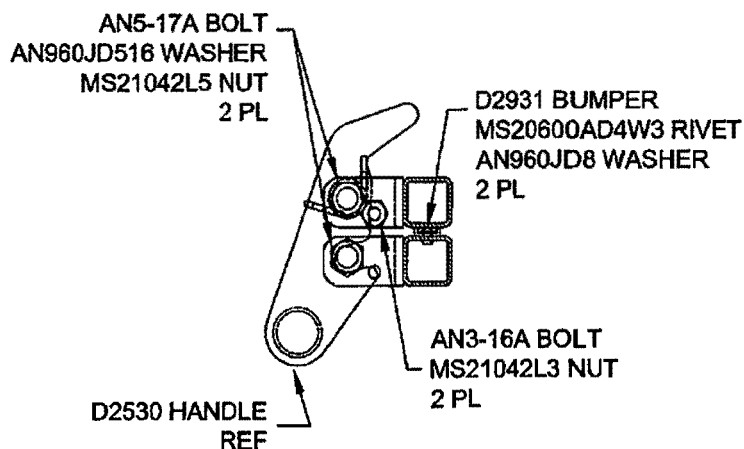
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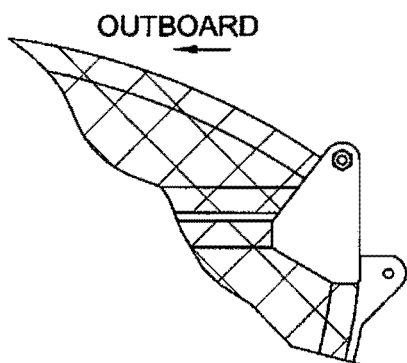


SPRING DETAIL

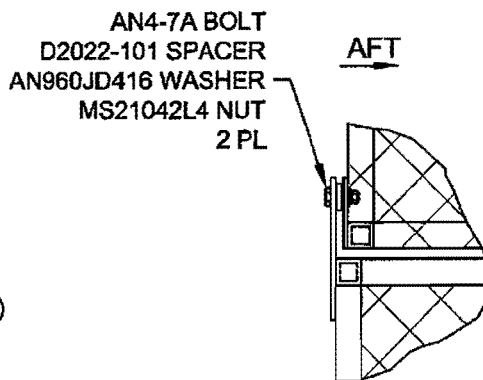


LATCH DETAIL

DETAIL J:  
HANDLE WELDMENT



HINGE DETAIL  
END VIEW, LOOKING AFT  
OTHER END OPPOSITE



HINGE DETAIL  
SIDE VIEW, LOOKING OUTBOARD.  
OTHER END OPPOSITE

DETAIL H:  
HINGE

**Figure 7 – Basket Replacement Parts**

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Revision: **A**

Date: 10.03.10

# Dart Aerospace Ltd

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